

532

DART AEROSPACE LTD	Work Order:	23983
Description: Strut	Part Number:	D3350-041
Dwg: D3350 Rev. A	Qty:	2
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	AP	05/08/09	2																				
2	MV	Cut blank: 0.750" x 0.750" x 15.00" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B0.750x00.750) Identify for D3350-1 Batch: <u>M17869</u>	SD	05.08.09	2																				
3	MV	Machine D3350-1 as per Folio FA496 and Dwg D3350 Identify as D3350-1	SD	05.08.09	2																				
4	QC2	Inspect parts as they come off the CNC machine	SD	05.08.09	2																				
5	QC8	Second check	SD	05.08.09	2																				
6	MV	Deburr and Tumble	SD	05.08.09	2																				
7	QC5	Inspect work to Step 6	EP	05/08/09	2																				
8	FP	Acid etch and Alodine as per QSI 005 4.1	FC	05 08 09	2																				
9	QC3	Inspect Acid etch and Alodine	SB	05/08/09	2																				
10	GA	Assemble as per Dwg D3350. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2324-5</td><td>Strap</td><td>023499</td></tr><tr><td>2</td><td>AN3-12A</td><td>Bolt</td><td>M15387</td></tr><tr><td>2</td><td>AN960JD10</td><td>Washer</td><td>M17639</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M15929</td></tr></table> Identify as D3350-041 and batch number using a fine point permanent marker	Qty	Part Number	Description	Batch	2	D2324-5	Strap	023499	2	AN3-12A	Bolt	M15387	2	AN960JD10	Washer	M17639	2	MS21042L3	Nut (or -3)	M15929	SP	05/08/09	2
Qty	Part Number	Description	Batch																						
2	D2324-5	Strap	023499																						
2	AN3-12A	Bolt	M15387																						
2	AN960JD10	Washer	M17639																						
2	MS21042L3	Nut (or -3)	M15929																						
11	QC5	Inspect work to Step 10	2	05-08-09	2																				
12	FP	Powder Coat Gloss White (Ref: 4.3.5.2) as per QSI 005 4.3	ML	05 08 09	2																				
13	QC3	Inspect Powder Coat	CL	05/08/10	2																				
14	ST	Identify and Stock	CL	05/08/10	2																				
15	AC	Cost / part: <u>57.67</u>	SUC	05.09.02	2																				
16	DC	Close W/O <u>57.67</u> Inspect Level 21	PS	05/08/11	2																				

Rev	Date	Change	Revised By	Approved
A	05.02.09	New issue	KJ/JLM	
B	05.07.11	Powder Coat now done after assembly	KJ/JLM	

RELEASED
05.07.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-08-09	10	need 2 more AN960 JD10 washers added to pick list and to the Dwg. per strut. Permanent change <i>J</i>				<i>[Signature]</i> 05-08-09	<i>2</i> 05-08-09

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 09, 2005
10:07 am

Work Order No	: 0023983	Department Code:	
Project Name	: D3350-041	Burden Flags	: NNNNNNN
Project For	: WK532	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3350-041	Invoice Number	:
Description	: Strut Assembly	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 2	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-09-05		
Est Finish Date	:	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods.	

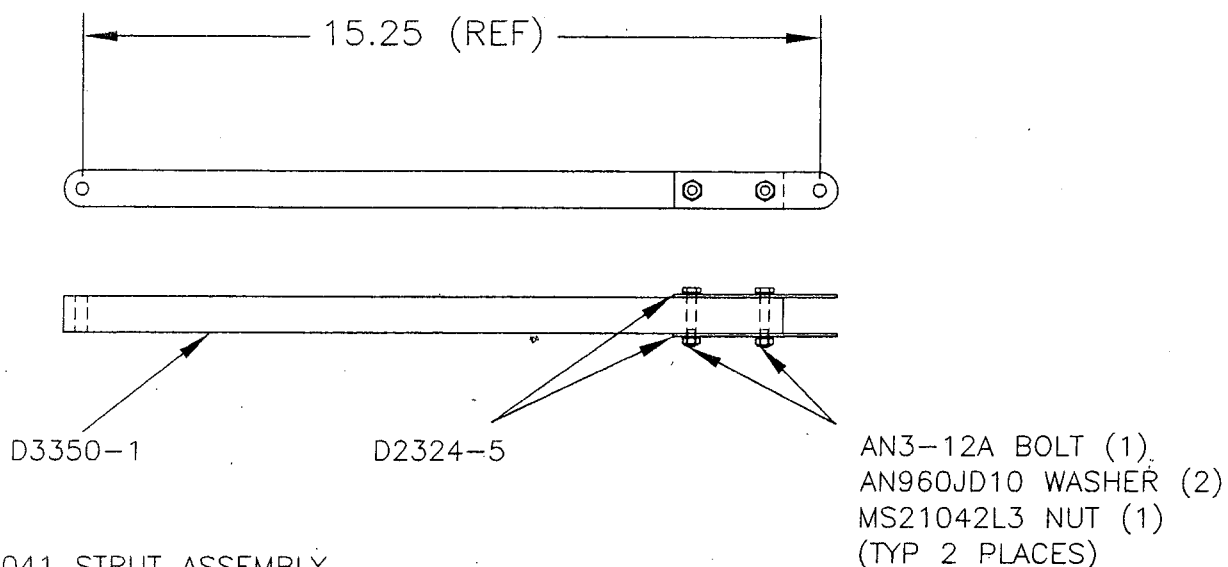
	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



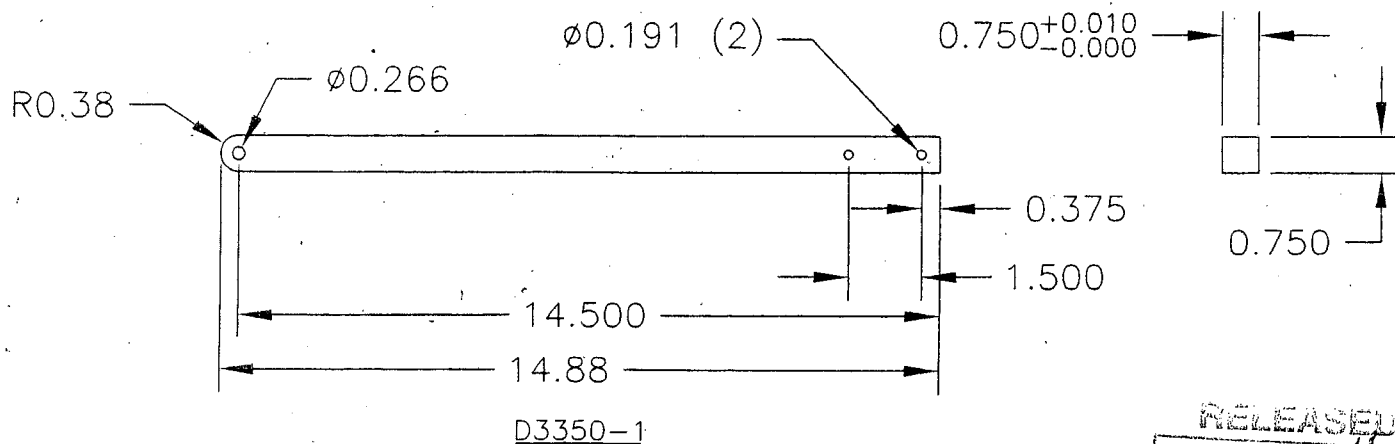
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3350	REV. A SHEET 1 OF 1
DATE 04.11.12		TITLE STRUT	SCALE 1:4
A	04.11.12	NEW ISSUE	

CONTROLLED COPY



D3350-041 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC: M6061T6B0.750X0.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

RELEASED
04.12.16

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